

# Work Order ID 73227

Friday, August 26, 2011 10:27:21 AM



Page 1

Item ID: D3315-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/9/2011 Req'd C: 00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/09/26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: / Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

1010 - 063

B11-8-30

5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-30

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5 u108/30

45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73227

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Page 2

Item ID: D3315-3

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Form using DT8179 Die and DT8157 as per Dwg D3315 Rev:

B SB 11/09/01

Brake NC

140

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

150

0.00



Large Fab

Large Fab

Memo

0.00

Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev:

☐ Qty Part Number Description Batch ☐ A/R

N/A 7560 Hardcoat Rod

11/17/04

5 JBL 11-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\* NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73227**

Friday, August 26, 2011 10:27:21 AM



Page 4

Item ID: D3315-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 0 11-09-07

200

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐ TCCA-PDA, Dart Aerospace Ltd. ☐ P/N: D3315-3, B/N: BXXXXX ☐ For Product Eligibility see PDA04-17 ☐ and Stock ☐ Location 5496

f

(5X)

SP 11-09-08

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/a 11-09-08

mf 11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, August 26, 2011 10:27:18 AM

Page 1

Work Order ID: 73227



Parent Item: D3315-3



Parent Item Name: Wearplate

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: A ☐ 05.05.12 ☐ New issue ☐ KJ/JLM ☐  
IPP Rev:B As per Rev B 06-03-24 JLM  
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

134.3000

2.296

12.08421



1311-8-30

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

134.3

116791

32.5

117500

101.8

117500

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

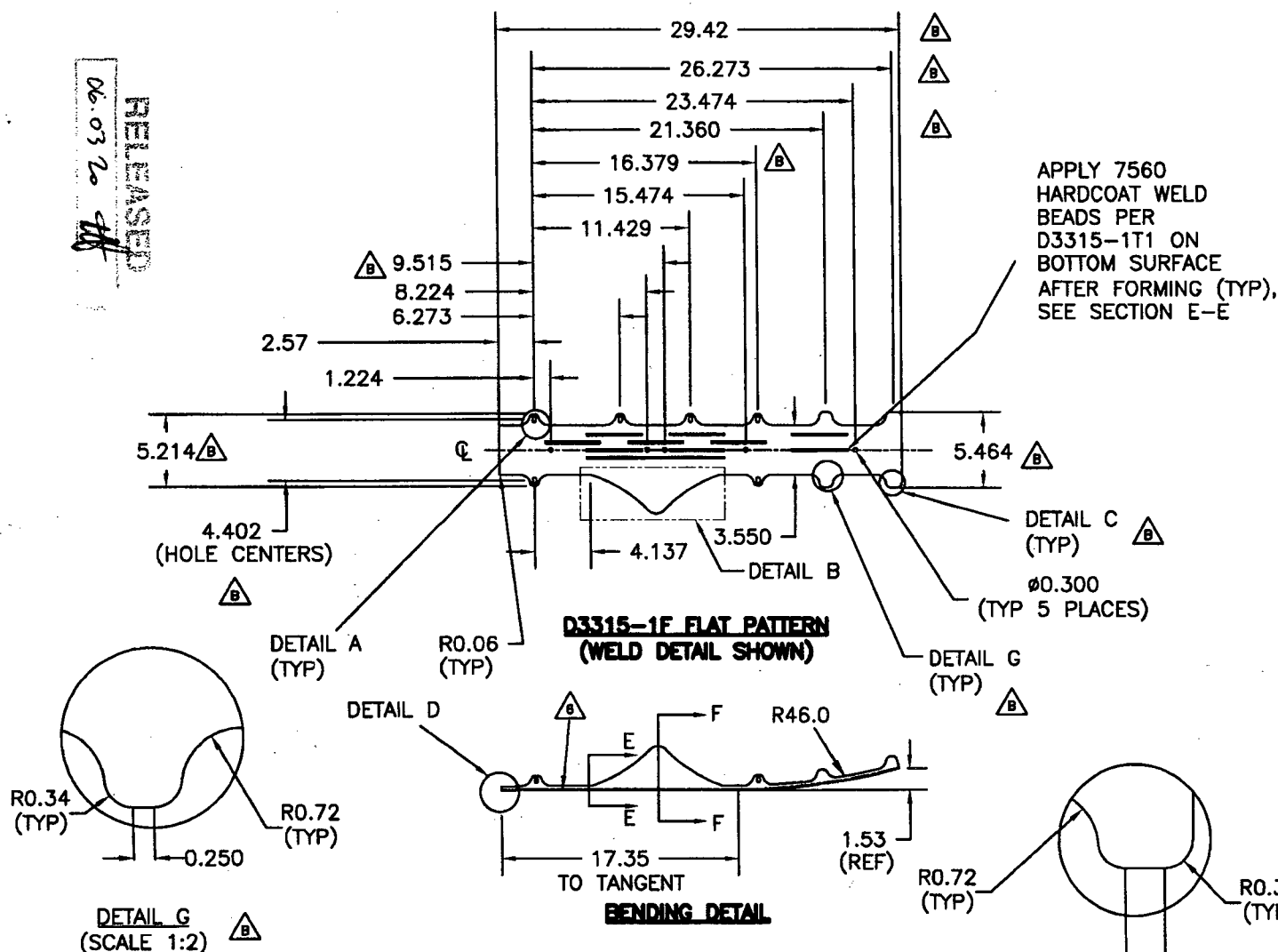
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NCR: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3315
DATE		TITLE
06.01.31		WEARPLATE
		SCALE
A	04.09.10	NEW ISSUE
B	06.01.31	UPDATE DIMENSIONS



**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

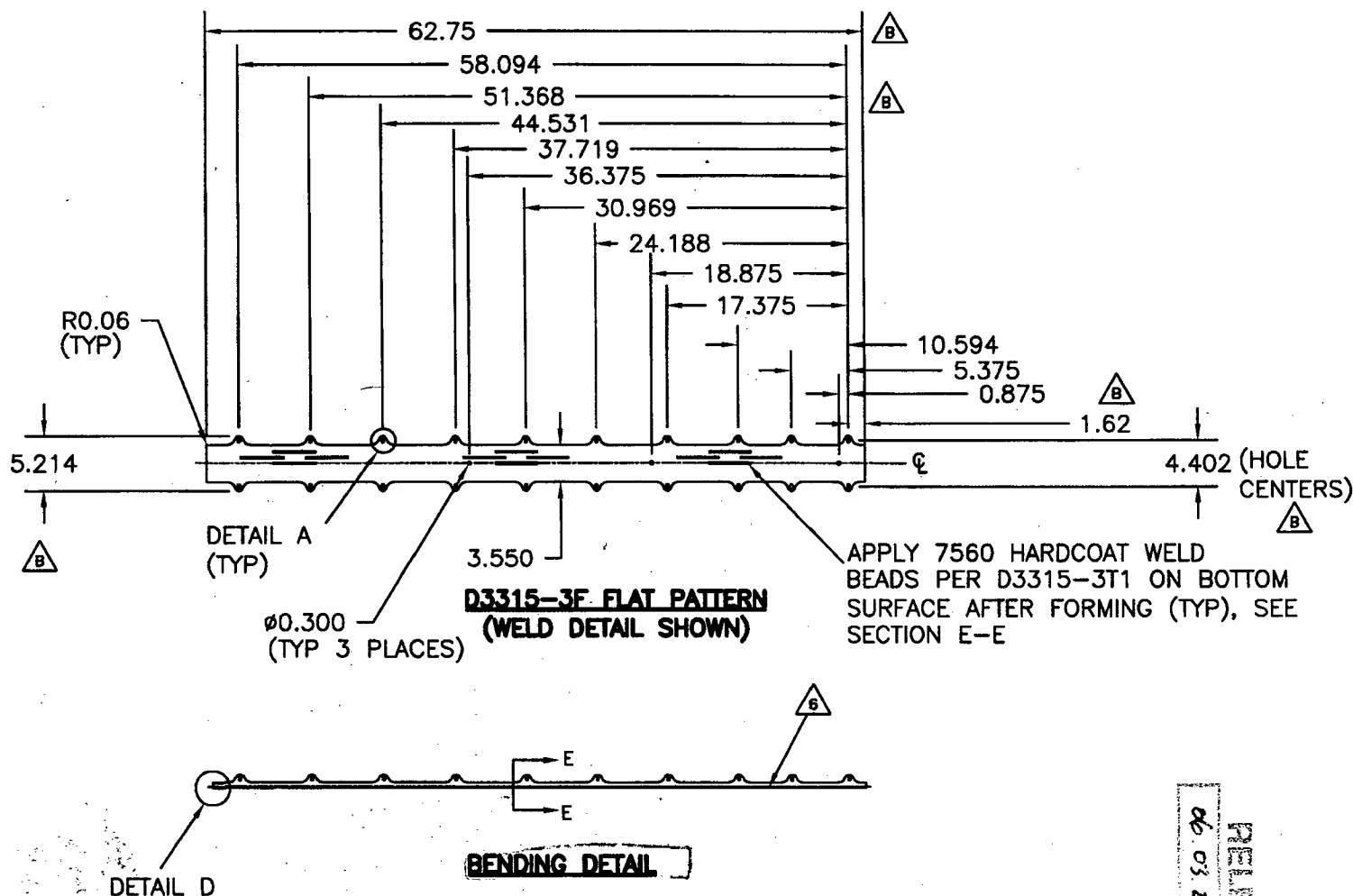
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- \*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

0.466  
SHOP COPY  
DETAIL C  
(SCALE 1:2)  
RETIRED  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73227

RELEASED  
06.03.20

**DART**

DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 2 OF 4
		SCALE	1:16	



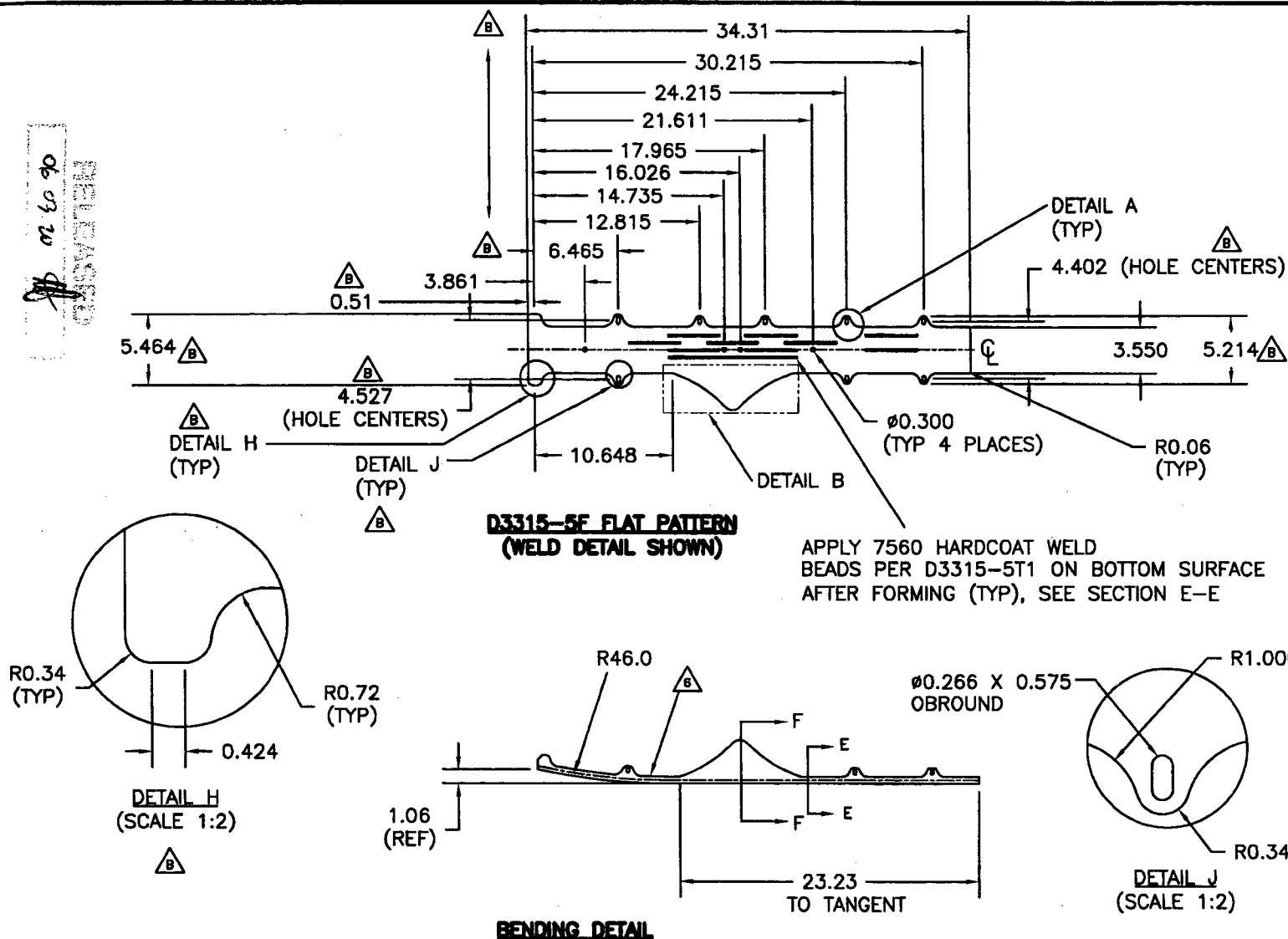
**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED  
26 03 20 *[Signature]*

**DART**

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE		SHEET 3 OF 4
				SCALE 1:12



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

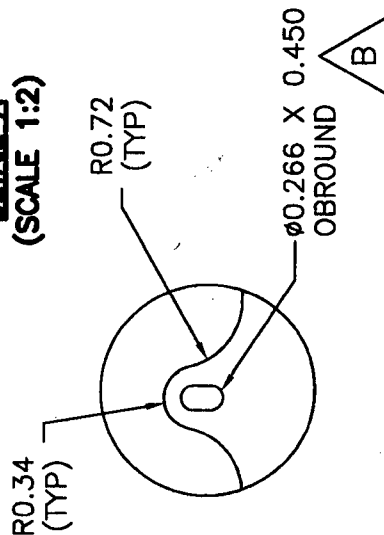
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

06.03.20

**DART**

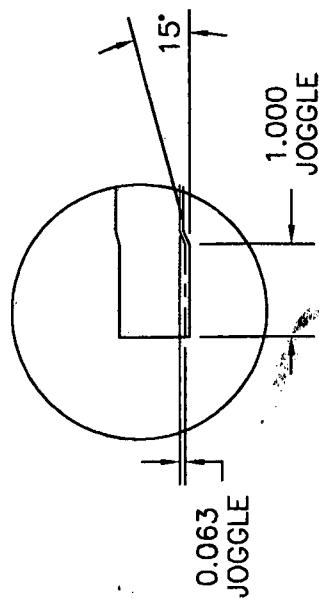
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31	TITLE WEARPLATE		SCALE NTS

**DETAIL A**  
(SCALE 1:2)

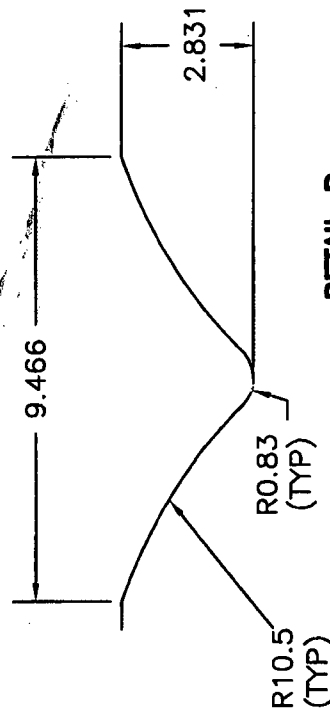


RELEASED

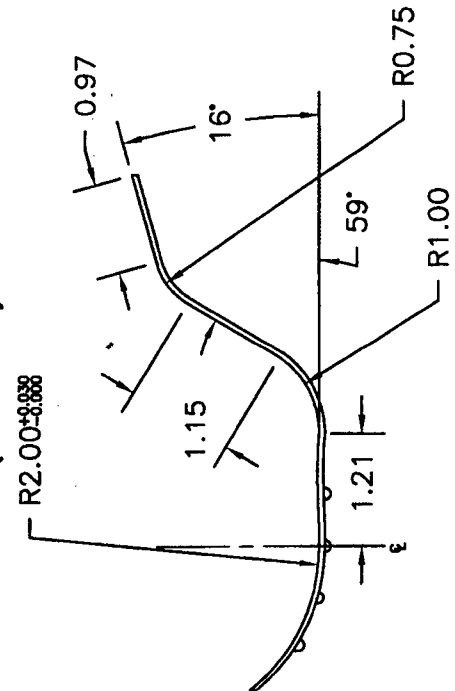
06.03.20



**DETAIL D**  
(SCALE 1:2)



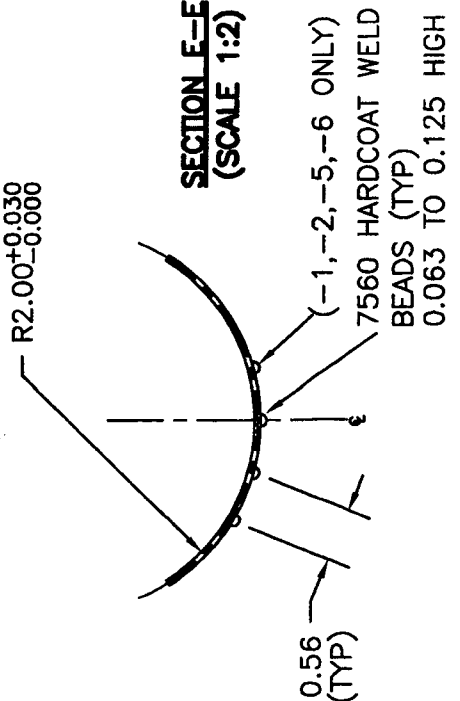
**DETAIL B**  
(SCALE 1:4)



**SECTION F-F**  
(SCALE 1:2)

R2.00<sup>+0.030</sup><sub>-0.000</sub>

**SECTION E-E**  
(SCALE 1:2)



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DART AEROSPACE LTD	Work Order: 73227
Description: WEARPLATE	Part Number: D3315-3
Inspection Dwg: D3315-3, Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article     ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.00	+ .006 - .001	3.01	2		V	IB02
266 X 266 X 1.00	± .010	266 X 450	2		V	
5.214	± .010	5.213	2		V	
4.402	± .010	4.395	2		V	
1.62	± .030	1.627	2		V	
.875	± .010	.875	2		V	
3.550	± .010	3.555	2		V	
5.375	± .010	5.375	2		T	IB01
10.594	± .010	10.594	2		T	
17.375	± .010	17.375	2		T	
18.875	± .010	18.875	2		T	
24.188	± .010	24.188	2		T	
30.969	± .010	30.969	2		T	
36.375	± .010	36.375	2		T	
37.719	± .010	37.719	2		T	
44.531	± .010	44.531	2		T	
51.368	± .010	51.368	2		T	
58.694	± .010	58.694	2		T	
62.75	± .030	62.750	2		T	
1.060	± .010	1.061	2		V	

Measured by: B	Audited by: S	Prototype Approval:
Date: 11-8-30	Date: 11/08/30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

